

Work Order ID 48240

Friday, June 26, 2009 8:57:04 AM

Page 1

Item ID: D3040-3

Accept

Revision ID: B

Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00

Required Date: 8/3/2009 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3040 | Rev B | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3041 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 9-7-2

8/09/07/02

B 9-7-2

(51)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8/09/07/06 counts
(457)

Work Order ID 48240

Friday, June 26, 2009 8:57:04 AM



Page 2

Item ID: D3040-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

9/7/6

SP

(5/X)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

u 090706

Picklist Print

Page 1

Friday, June 26, 2009 8:57:04 AM

Work Order ID: 48240

Parent Item: D3040-3RevB

Parent Item Name: Mounting Lug



Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6B0.187X04.00 0 | | Purchased | No | | | 100 | f | 0.0000 | 14.9095 | | | |
|   | | | | | | | | | | | | |
| 6061-T6 Bar .178 x 4.00 | | | | m 106649 | | HS 9-7-2 | | | | | | |

Date: Thursday, 28/05/2009 9:11:50 AM
 User: Julie Dawson

Process Sheet

| | |
|-------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MOUNTING LUG |
| Job Number : 48240 | |
| Estimate Number : 11535 | |
| P.O. Number : | Part Number : D30403 |
| This Issue : 28/05/2009 S.O. No. : | Drawing Number : D3040 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : // Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 42945 | Material : |
| Written By : | Due Date : 04/06/2009 Qty: 40 Um: Each |
| Checked & Approved By : <u>JULIA DAWSON</u> | |
| Comment : Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:C Now on Waterjet 07-03-07 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0187X04000 | 6061-T6 Bar .178 x 4.00 |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.3718 f(s)/Unit Total : 14.8722 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 alum plate 0.188" thick

Batch: 106649 B 97-2

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3041
 Dwg Rev: B
 Prog Rev: B

B 97-2

2-Deburr if necessary

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEB 97-2

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECKS 09167106 (KSL)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:50 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 48240

Part Number: D30403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

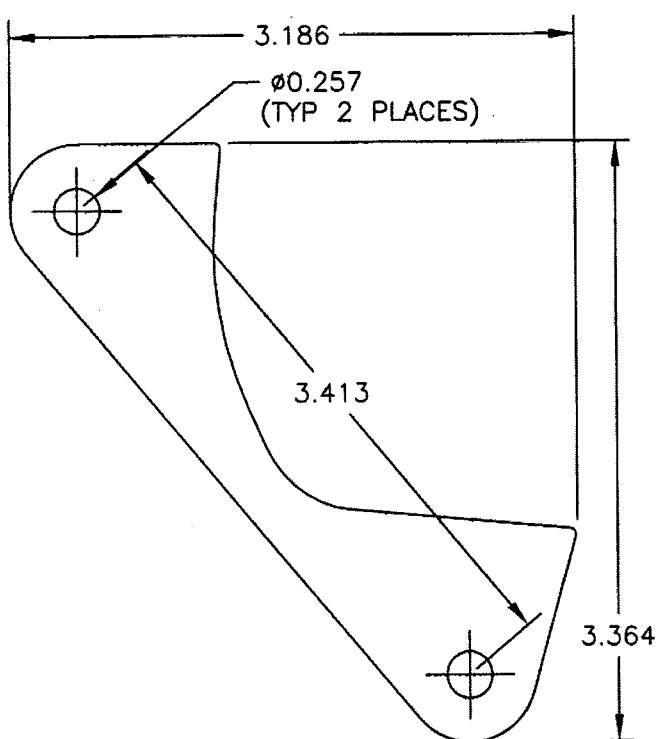
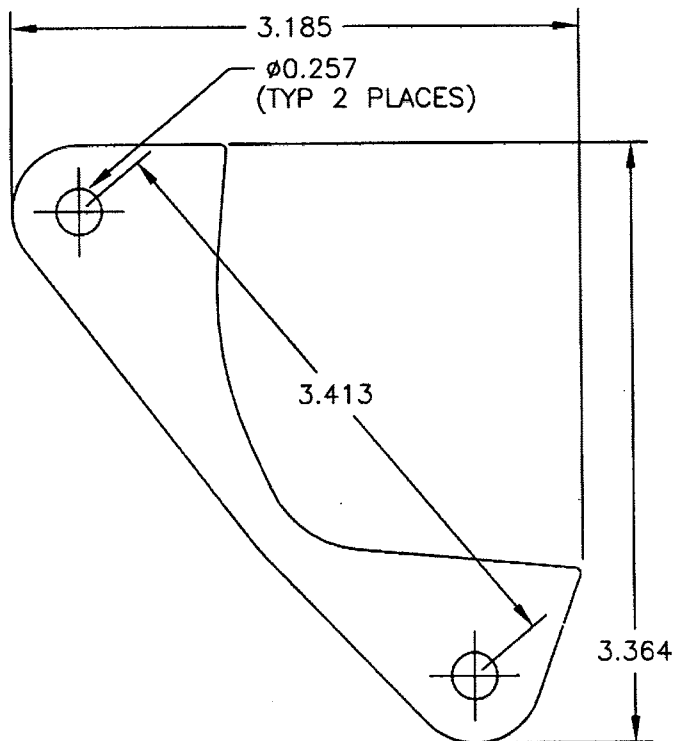
NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|---------------------------------------------------------------------------------------|
| A | 07.04.20 | New Issue | KJ/JLM |  |

DART**RELEASED**
01.09.04

| | | | |
|------------------|----------------|----------------------------------------------|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED H | APPROVED H | DRAWING NO. D3040 | REV. B SHEET 1 OF 1 |
| DATE 01.09.04 | | TITLE MOUNTING LUG | SCALE 1:1 |
| A | 01.06.27 | NEW ISSUE | |
| B | 01.09.04 | CHANGED PROFILE 5 DEGREES | |

D3040-1D3040-3**NOTES**

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK (REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
48240

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